

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 01.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029948**Date Inspected:** 23-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Jesus Cayabyab & Bernie Docena			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** See Below**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Edward Leach was at the American Bridge/Flour (ABF) job site at Yerba Buena Island between the times noted above in order to monitor Smith Emery Quality Control (QC) functions and the in process work being performed by ABF personnel. The following items were observed:

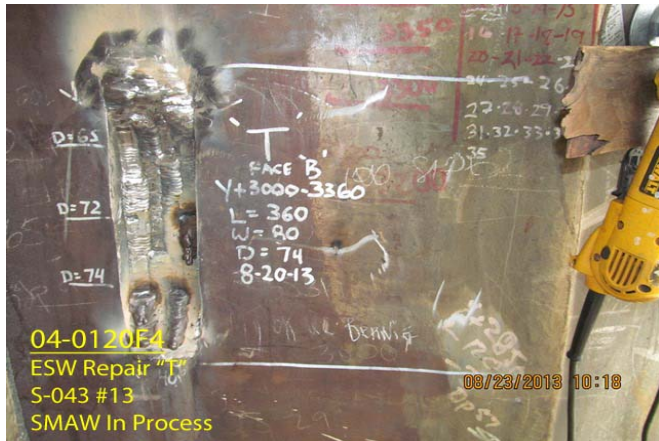
RWR201308-004

ESW S-043, Location "T" Face B

The QAI periodically observed ABF welding personnel Mike Jimenez utilizing the Shielded Metal Arc Welding (SMAW) process in the vertical (3G) position with Atom Arc E7018-1 H4R, 5/32" diameter electrode to continue welding excavation for weld repair. The welding is taking place on the exterior (west) side at joint T, weld #S-043 on Face B side for a repair designated as 201308-004. Excavation dimensions are noted as Y=3000mm-3360mm, Length=360mm, Width=80mm, Depth=74mm. The QAI observed the interpass temperature was maintained at approximately 360 degrees Fahrenheit with electric heating coil blankets through a heat induction system and a rose bud torch. The QAI verified interpass temperature with a thermal heat gun. As welding continued the QAI periodically verified welding parameters at approximately 140 amperes per ABF-WPS-D1.5-ESW-80-100TR. The welder was also observed using proper interpass cleaning methods with a slag hammer and a wire brush. QC Inspector Jesus Cayabyab was monitoring the progress of this repair on this date.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

General conversations with ABF/JV QC NDT personnel relevant to work and testing performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Leach,Ed	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
